

Date: Wednesday, 20/05/2009 1:54:34 PM
 User: Melanie Fauteux

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STEP SPACER |
| Job Number : | 48090E | | |
| Estimate Number : | 13129 | | |
| P.O. Number : | | Part Number : | D37202 |
| This Issue : | 20/05/2009 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3720 REVA |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 47644E | Drawing Revision : | A |
| | | Material : | |
| Written By : | | Due Date : | 27/05/2009 |
| Checked & Approved By : | <u>MF 09-05-20</u> | Qty: | 10 |
| Comment : | Est Rev :A New Issue 08-01-11 EC verified by DD | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S125 | 6061-T6 .125 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0893 sf(s)/Unit Total : 0.8925 sf(s)

6061 T6 sheet .125

Batch: 110562 B9-6-10

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3720

Dwg Rev: AProg Rev: AB9-6-10

2-Deburr if necessary

B9-6-10

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

B9-6-10**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

B9-6-10**Comment:** SECOND CHECK

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

C'sink as per dwg D3720

Ep 09/06/17 11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 1:54:34 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 48090E

Part Number: D37202

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



(-2)

Comment: INSPECT WORK TO CURRENT STEP

8060617 (X10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 09-06-18 (X11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(11)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-06-18

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

09/06/22 (11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/23 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-06-22

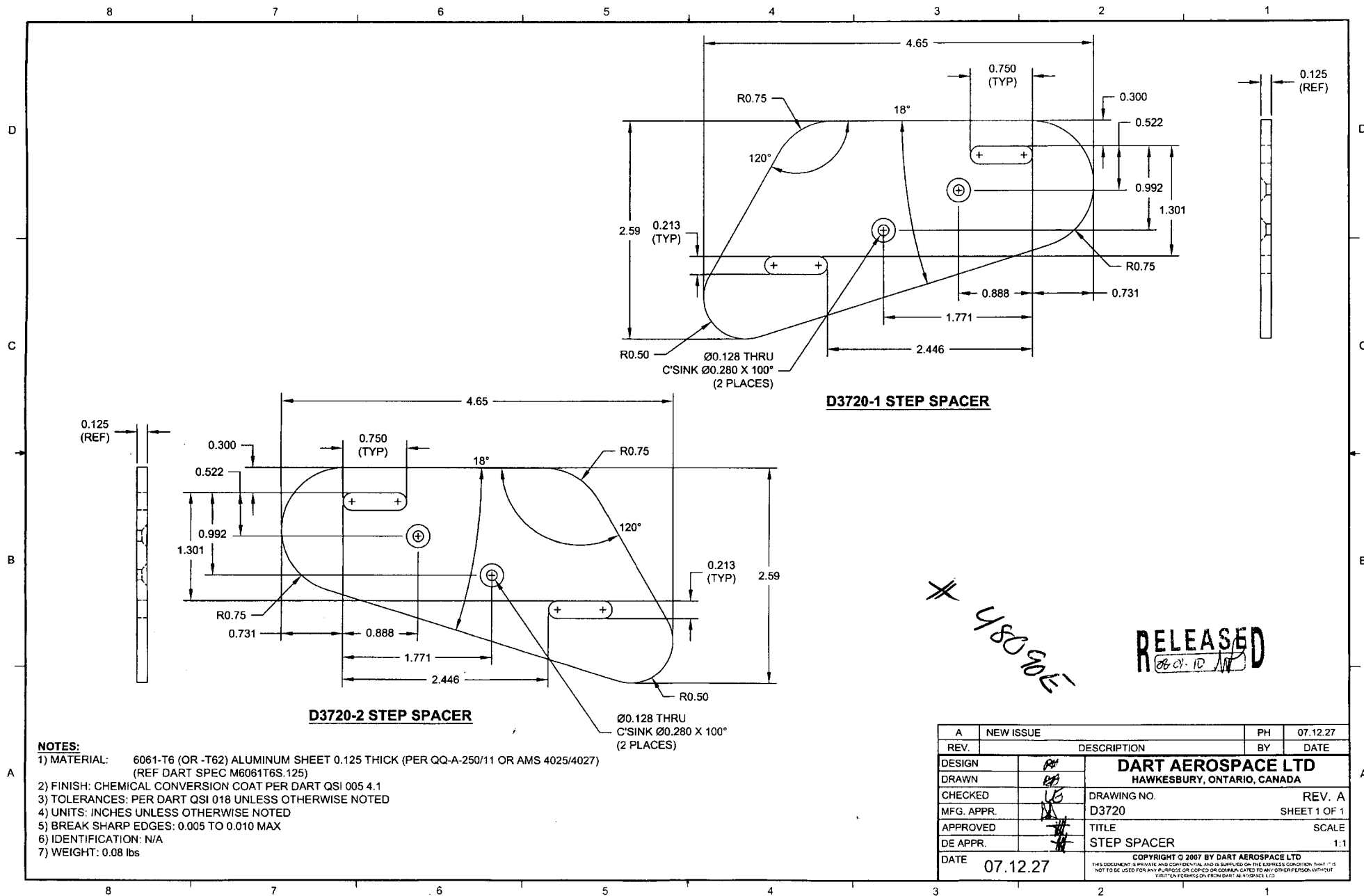
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



48090E

RELEASED

| REV. | NEW ISSUE | DESCRIPTION | PH | 07.12.27 |
|------------|-----------|-------------|----|----------|
| DESIGN | | | BY | DATE |
| DRAWN | | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 07.12.27 | | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3720
REV. A
SHEET 1 OF 1

TITLE
STEP SPACER
SCALE
1:1

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries